



Jefferson Lab Alignment Group

Data Transmittal

TO: Ed Daly	DATE: Mar 28 2005
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FROM: Richard Schwartz	Checked:	# : L964r
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DETAILS:

This data transmittal has been revised to reflect the new inspection survey on end cap using the correct mandrel (dummy bayonet).

Below are the results of the 12 GEV Renaissance cryomodule supply end cap inspection performed on Mar 8, 2005 and the bridging ring inspection performed on Nov 16, 2004. On the end cap, a right handed coordinate system was established with the central axis running perpendicular to the end plate through the center aperture (origin). An average line constructed between the primary and shield bayonets was used to control roll. A +X is to the beam left, +Z downstream, and +Y is above. Values are in inches and degrees.

Note: The coordinates listed below are to a single point at the top of each bayonet flange. The pitch and roll measurements are to a mandrel inserted in each bayonet support. These angular values are determined over a 7 inch length of the mandrel which are accurate to within 0.03 degrees.

The results of the Bridging rings are based on stick mic measurements taken every 45 degrees clockwise looking from the 0" to the 14" cross-section.

Description	X	Y	Z
Primary Bayonet	15.84	26.94	-6.00
Shield Bayonet	15.98	26.98	-17.92

Description	Pitch	Roll
Primary bayonet	0.14° (top is downstream)	0°
Shield bayonet	0.44° (top is downstream)	0°

Description	0-180	45-225	90-270	135-315	Flatness
Bridging Ring 231480-1					
0" from Vacuum Tank	38.03	38.04	38.12	38.19	0.028
7" from Vacuum Tank		38.09	38.12	38.17	
14" from Vacuum Tank	38.04	38.90	38.08	38.13	
Bridging Ring 231480-2					
0" from Vacuum Tank	37.98	38.03	38.15	38.20	0.048
7" from Vacuum Tank		38.08	38.12	38.19	
14" from Vacuum Tank	38.08	38.11	38.18	38.14	